

Ship Aug 14

Work Order ID 105592

105592

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August-08-13 11:32:25 AM

Item ID: D2701

D2701

Accept

N9000040100

Setup Start *NS1*

Revision ID:

B 105592

Stop *NS2*

Item Name: Upper Arm Clevis

Start Date: 8/08/13

Start Qty: 4.00

4

Cust Item ID:

Required Date: 8/09/13

Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2701	Rev B								

100

0.00

100

Waterjet

Memo

0.00

FLOW CNC Waterjet

CUT AS PER FILE

PROG REV: B

DWG REV: B

6061 .250 Steel

DEBURR

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Memo

0.00

Quality Control

16 0 13.08.11

16 0 13.08.11

PTU

D

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August-08-13 11:32:25 AM

Item ID: D2701 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Upper Arm Clevis
 Start Date: 8/08/13 Start Qty: 4.00 *4* Cust Item ID:
 Required Date: 8/09/13 Req'd Qty: 4.00 *4* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				16			
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140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				16			1 DAS 05 13-08-14
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150 *150* Powdercoat Powder Coating	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3 Memo	0.00 0.00	white						
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START TIME: 9:30 FINISH TIME: 10:00 OVEN TEMPERATURE: 320°F

16x8 M-13/08/15

M126125

Work Order ID 105592

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Item ID: D2701

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Upper Arm Clevis

Start Date: 8/08/13 Start Qty: 4.00 *4*

Cust Item ID:

Required Date: 8/09/13 Req'd Qty: 4.00 *4*

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00							
160									
QC	Memo	0.00							
Quality Control									
170	Identify as per dwg & Stock Location: <u>5T016</u>	0.00							
170									
Packaging	Memo	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

16x d All 13/08/15

16x 11.13-08-15

13/8/2013

MCS 13-08-16

Picklist Print

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Work Order ID: 105592

Parent Item: D2701

Parent Item Name: Upper Arm Clevis

Start Date: 8/08/13

Required Date: 8/09/13

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP C00.11.01Removed P/O for Powder Coat - in house processEC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.250		Purchased	No				sf	107.3500		0.08	.32	13.08.11	
6061T6 SHEET .250													

Location

Loc Qty

Loc Code

MAT021

107.35

116808

23.8

121194

26.3

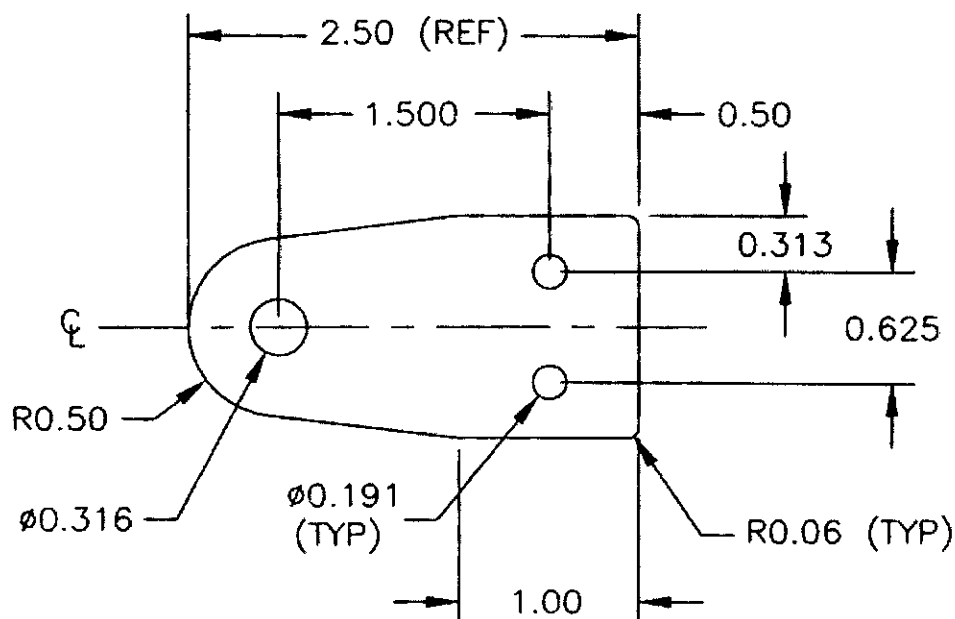
125024

57.25

DA COPY
0211551

RELEASED
99.11.02. KE

DESIGN KE		DRAWN BY KE		DART AEROSPACE LTD., HAMKESBURY, ONTARIO, CANADA	
CHECKED GP	APPROVED JH	DRAWING NO. D2701		REV. B	
DATE 99.10.20		TITLE STA 84 ARM UPPER CLEVIS		SHEET 1 OF 1	
A	97.09.10	NEW ISSUE		SCALE 1:1	
B	99.10.20	UPDATE TOLERANCE AND FINISH			



45

W05592

NOTE: DEBURR ALL EDGES R0.030-R0.060
PART IS SYMMETRIC ABOUT CENTERLINE
MATERIAL: 6061-T6 OR 6061-T651 (QQ-A-225/8
OR QQ-A-200/8 OR QQ-A-250/11)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: *fat* Date: 13/08/21QA Closed: *fat* Date: 13/08/21

Work Order: <u>105592</u> Part No. <u>D2701</u> NCR No. <u>13-2968</u>				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input checked="" type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input checked="" type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
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Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data <input checked="" type="checkbox"/> Equip/Tooling <input checked="" type="checkbox"/> Operator <input type="checkbox"/> Material <input type="checkbox"/> Setup <input type="checkbox"/> Other <input type="checkbox"/> Process <input type="checkbox"/> Supplier <input type="checkbox"/> Training <input type="checkbox"/> Unapproved <input type="checkbox"/>	13/8/21	100		φ0.191 holes are oversized from waterjet up to φ0.205", tapered.	<i>UP</i> 13/8/21	Acceptable. Ensure there are no ridges from waterjet, Remove if necessary Ensure there are no ridges from waterjet, Remove if necessary	<i>A</i> 13.08.21	DAS 27 9-89 13 8-20	DAS 16 9-89 13/08/21

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped. <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input checked="" type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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RC equip/tooling
inexperience

2
10
10